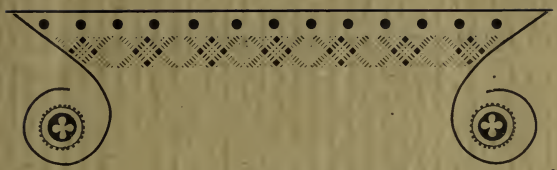


The Tubular Rivet Company,

Manufacturers,

BOSTON, MASS., U. S. A.

Messrs.Noble & Cooley,

New York,

N.Y.

THE TUBULAR RIVET CO.

No. 55 LINCOLN STREET,

MELLEN BRAY,
Sect. and Treas.

BOSTON. Nov.8,1890.

Gentlemen:-

We have your favor of the 6th and have rivetted the sample as requested though we are not sure that we understand just how the work is to be done. We also mail you one of our catalogues and enclose discount sheet which will give the information required. Hoping that we may be favored with your order, we are,

Yours truly,

The Tubular Rivet Co.

Dictated by W.C.Bray

A DISCOUNT

IF ORDERED IN THE FOLLOWING QUANTITIES,

— ON —

SMALL, Shoe and No. 1 Belt Rivets.

Discount 5 % *on orders of less than* 25 M.

" 5 & 10 " " " from 25 M. to 100 M.

" 5 & 5 & 10 " " " 100 M. or over.

— ON —

No. 3 Belt or Harness Rivets.

Discount 10% *on orders of from 25 M. to 100 M.*

Discount 20% *on orders of 100 M. or over.*

An extra discount of 1 per cent will be allowed for cash, if paid before the 10th of the month following the sale.

An order for 100 M. may include all kinds of above and the full 100 M. discount of each kind will be allowed.

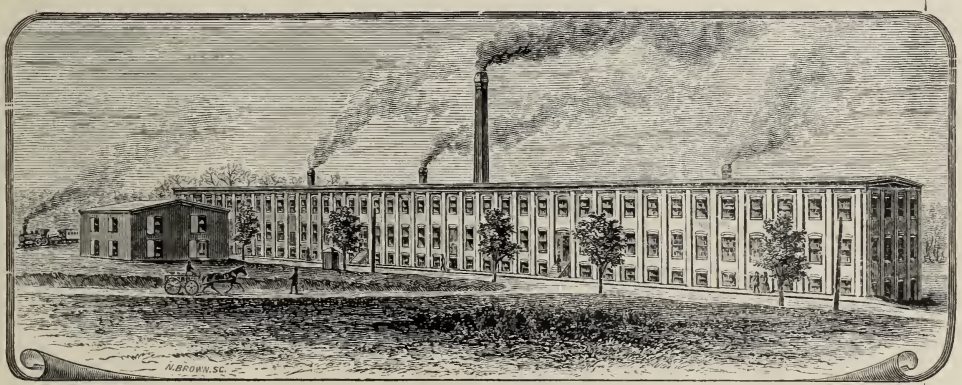
Freight will be prepaid when ordered in 100 M. lots.

The Tubular Rivet Company.

RIVETS AND RIVETING MACHINES

FOR

BOOTS AND SHOES, HARNESSES,
SAMPLE CASES, BELTING,
TRUNKS, STRAPS, ETC.



MANUFACTURED BY

THE TUBULAR RIVET COMPANY,

55 LINCOLN STREET,

BOSTON, MASS., U. S. A.

FACTORY AT WOLLASTON HEIGHTS, MASS.

The Machines for setting the

Tubular Rivets

are simple in construction, but there are a few important points which ought to be thoroughly understood.

Careful attention should therefore be paid to the explanations contained in the following pages.

WITH the exception of the "Hand Sett," our Machines are not sold, but leased for a small annual rental, so that no large outlay is necessary.

We agree to keep these leased machines in repair, and to replace without charge any part which may break, providing there is any imperfection either in material or workmanship.

If, however, a machine is destroyed, or if parts are lost or broken, except as provided for above, a charge will be made.

IMPORTANT DIRECTIONS.

1. SET all rivets with a FIRM, STEADY PRESSURE of the foot on the treadle, NOT WITH A BLOW.

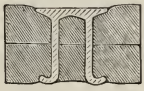
2. AVOID using rivets which are either TOO LONG or TOO SHORT. For hard, firm stock the rivet should be about $\frac{1}{32}$ longer than the thickness of the material to be riveted; for spongy stock, a trifle less.

3. WHEN practicable, use different lengths of the same rather than of different styles of rivets. This will necessitate less changes in the machine, and save time.

4. IF a machine is to be used for more than one style of rivets, the parts *must* be changed as described under the descriptions of the various machines.

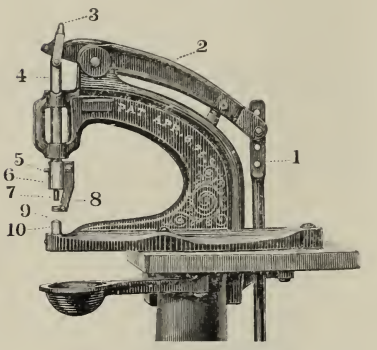
5. WHEN the ANVIL becomes WORN, it should be replaced, or the result will be a crippled rivet and imperfect work. For illustration, see opposite page.

THE cuts shown below give an accurate idea of the importance of using a perfect Anvil-tip, and the result of using one which has become worn.

Sectional views of Tips.	Sectional views of Rivets	Plan of Clinch made
		
Perfect.	set with Perfect Tip.	with Perfect Tip.
Worn.	set with Worn Tip.	with Worn Tip.

EVERY machine will be furnished with one or more *extra* Tips, according to the number of styles of rivets for which it is fitted.

When a Tip becomes worn, return it and a new one will be sent without charge. In this way a perfect one can be kept constantly on hand.



EXPLANATION OF PARTS.

1. Rod.

2. Lever. After long use this part is liable to become worn at the point directly over the spindle. When badly worn it should be replaced.

3. Yoke.

4. Spindle.

5. Pocket-Screw.

6. Pocket-Hub.

7. Taper. As the taper is made to fit the head of the rivet, each style of rivet requires the taper made especially for it.

8. Jaws, consisting of the Springs and Steel Pocket which holds the rivet. As it is important to have the rivet held firmly while being set, the hole through this pocket must be of the same diameter as the outside of the rivet; therefore, if rivets having different diameters are to be used, Jaws will be required for each style.

9. Anvil-Tip. A part of the machine to which particular attention must be paid, as the rivet cannot be properly clinched after this has become worn. The *Tips*, which must be changed for rivets of different diameters, are marked as follows:

For No. 1 Rivets	1 R.
For No. 3 Rivets	3 R.
For SMALL Rivets	S R.

10. Anvil-Chuck. The socket for holding the Tip.

11. All parts liable to wear should be kept *well oiled*, especially the top of the *spindle* on which the lever bears.

The above parts have the same name whether used on the large or small machines.

When ordering, give the name of the part wanted and the style of machine on which it is to be used.

DIMENSIONS OF MACHINES.

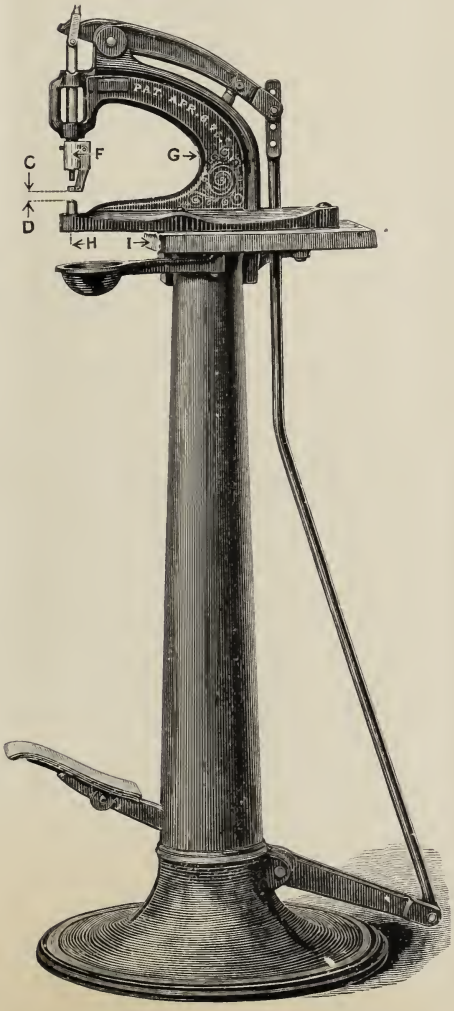
No. of Machine.	Weight, lbs.	Height, ft. in.	From F to G.	From H to I.	From C to D.
1	6	8	$2\frac{7}{8}$ in.		$\frac{7}{8}$ in.
2	20	Varied by height of Bench.	$4\frac{1}{8}$ "		$\frac{1}{2}$ "
3	127	4 4	$6\frac{3}{4}$ "	$4\frac{1}{4}$ in.	$\frac{5}{8}$ "
4	130	4 4	$6\frac{3}{4}$ "	$4\frac{1}{4}$ "	$\frac{3}{4}$ in. with $\frac{3}{16}$ Jaws. $\frac{9}{16}$ " $\frac{5}{16}$ "
Style 2. *4*	131	4 4	$6\frac{3}{4}$ "	$4\frac{1}{4}$ "	$\frac{7}{8}$ in. with $\frac{3}{16}$ Jaws. $\frac{1}{2}$ " $\frac{8}{16}$ "
5	228	4 $6\frac{1}{2}$	$7\frac{1}{2}$ "	$7\frac{1}{2}$ "	$1\frac{5}{16}$ in. with $\frac{3}{16}$ Jaws. $1\frac{3}{16}$ " $\frac{5}{16}$ "
7	344	4 8	16 "		$1\frac{5}{16}$ with $\frac{3}{16}$ Jaws.* 1 " $\frac{8}{16}$ "
8	263	4 8	16 "	$10\frac{1}{2}$ " ‡	$1\frac{3}{16}$ in.†
9	39	Varied by height of Bench.	$6\frac{3}{4}$ "	$4\frac{3}{4}$ "	$\frac{5}{8}$ in.
10	493	5	20 "		$1\frac{5}{16}$ with $\frac{3}{16}$ Jaws. $1\frac{1}{4}$ " $\frac{8}{16}$ "
11	448	4 11	$10\frac{1}{2}$ "		Hand-Feed, same as No. 8. Self-Feed, same as No. 7.
12	130	4 4	$6\frac{3}{4}$ "	$4\frac{3}{4}$ "	$\frac{3}{4}$ with $\frac{3}{16}$ Jaws. $\frac{9}{16}$ " $\frac{5}{16}$ "

* These distances can be increased $\frac{5}{16}$ in. if so ordered.

† This distance can be increased $\frac{7}{16}$ in. if so ordered.

‡ This distance can be increased to 16 in. if so ordered.

These changes are not advised unless necessary.


C
F
G
D
H
I

SMALL RIVETS.

DIAMETER OF HEAD. $\frac{13}{64}$

DIAMETER OF TUBE. $\frac{1}{8}$

FOR very light Straps, Seams of Boots and Shoes, light Fancy Leather work, etc.

Lengths	2	2½	3	3½	4
made,	16	16	16	16	16

Price $1.10 *per Thousand. Discount*

SHOE RIVETS.

DIAMETER OF HEAD. $\frac{9}{32}$

DIAMETER OF TUBE. $\frac{9}{64}$

FOR Brogans, Plow-Shoes, Shawl Straps, Fancy Leather work, etc.

Lengths	2½	3	3½	4	4½	5
made,	16	16	16	16	16	16

Price $1.10 *per Thousand. Discount*

Our ***Case Rivets*** are recommended for use where an oval head is preferred, and the length required is over $\frac{5}{16}$. The centre of this head, which is convex, is surrounded by a narrow flat rim which makes a very neat finish and insures a perfect setting. These rivets are made both in the No. 1 and No. 3 sizes, and the diameter of the heads, the lengths made, and the prices are the same as for the Nos. 1 and 3 Belt Rivets. This style is not kept in stock but will be made to order.

No. 1 BELT RIVETS.

DIAMETER OF HEAD. $\frac{5}{16}$

DIAMETER OF TUBE. $\frac{9}{64}$

FOR Belting, Halters, Straps, Sample Cases, Trunks, light Harness work, etc.

Lengths made,	3 16	3½ 16	4 16	4½ 16	5 16	5½ 16	6 16	6½ 16	7 16
Price per Thousand,			$1.10			$1.20		$1.30	

Discount.....

No. 3 BELT RIVETS.

DIAMETER OF HEAD. $\frac{11}{32}$

DIAMETER OF TUBE. $\frac{3}{16}$

FOR general Harness work, Heavy Belting, Horse Collars, Straps, Sample Cases, Trunks, etc.

Lengths Made and Price per Thousand.

4	4½	5	5½	6	6½	7	7½	8	8½	9	9½	10
16	16	16	16	16	16	16	16	16	16	16	16	16
$1.75	$1.85		$1.95		$2.05		$2.15		$2.25		$2.35	

Discount .....

☞ The prices given are for japanned, coppered or tinned rivets. ***State plainly which plating is desired.***

☞ For NICKEL and SILVER PLATED rivets add 10c. per thousand to the price of the SMALL, Shoe and No. 1 Belt, and 15c. per thousand to the No. 3.

☞ Brass Rivets and special styles made to order.

No. 1 or HAND SETT.

A MACHINE designed especially for repairing, though by no means confined to that class of work. HARNESS MAKERS, TEAMSTERS, FARMERS and others who have occasion to mend a broken harness or strap will find it a great convenience; and for those using but few rivets it is the best machine.

The same Pocket, Spindle and Anvil are used for Shoe and No. 1 Belt Rivets.

No. 3 Belt and

Rivets require separate parts for each.

These changes must be made to insure good work.

DIRECTIONS

To Adjust the Machine for Riveting Materials of Different Thicknesses.

PLACE the pieces to be riveted between the *Anvil* and *Pocket*, holding them in place by pressing the Lever down; then by means of the *Adjustable Screw* raise or lower the Spindle, leaving it so that the material is tightly compressed between the Anvil and Spindle *when the Lever is down.* The rivet can then be placed in the pocket and be properly set.

This machine is packed in a strong paste-board box, with full directions for use.

Two-Thirds Full Size.

Anvil.

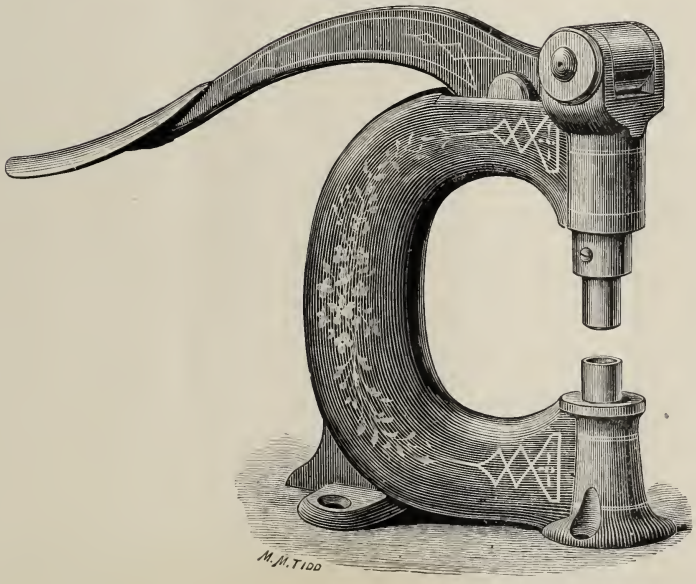
Pocket.

Spring for Raising Pocket.

Spindle.

Adjustable Screw.

One-Third Full Size.



No. 1 or HAND SETT.

(For dimensions see page 8.)

Price, each - - - - - - - - - $3.50

Extra Parts, including Anvil, Pocket and Spindle - .75

No. 2 or SMALL BENCH SETT.

A LIGHT, easy working machine, suitable for riveting *Trunk and Shawl Straps, Suspenders, Fancy Leather Work, etc.* By changing the parts as explained below, the following rivets can be used:

, SHOE and No. 1 BELT.

The same Jaws and Anvil-Tip are used for both the Shoe and No. 1 Belt Rivets, but a special Taper is required for each.

The

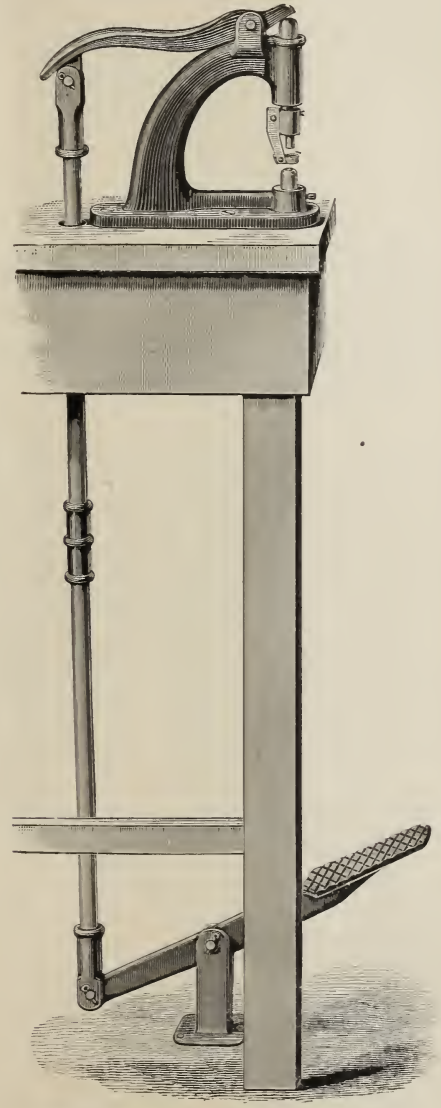
Rivets require special Jaws, Taper and Anvil-Tip.

Jaws, per pair	$1.50
Anvil-Tip	.10
Taper	.25
Loop Anvil, either style . . .	.75

(For illustration of Loop Anvils see page 38.)

THESE charges are made only for the first year, after which the amount of rental will be the same without regard to the number of styles for which the machine is fitted. These extra parts must be returned with the machine.

NOTE. — If an order for at least 25 thousand rivets accompanies the order for a machine, no charge will be made for one set of extra parts.



No. 2 or BENCH SETT.

(For dimensions see page 8.)

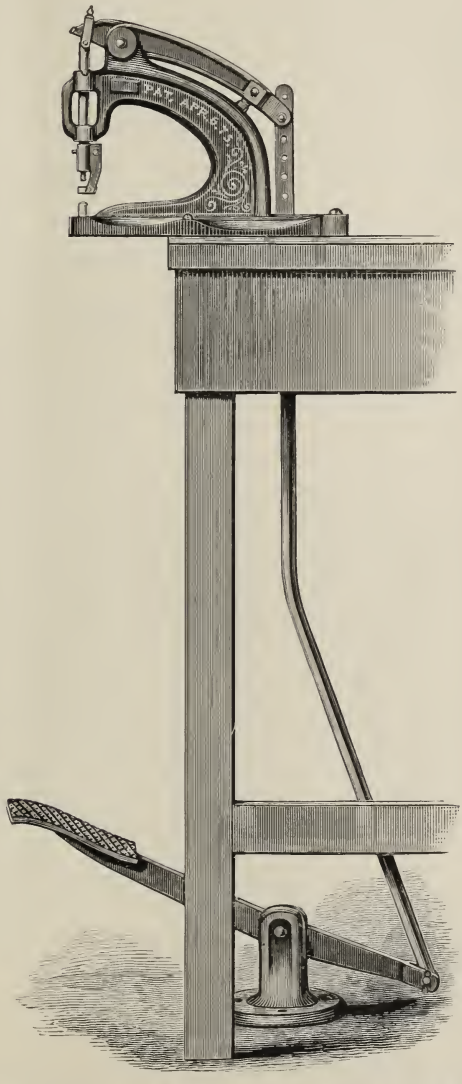
Under rental, per year - - - - - $2.00

(For value of this machine see page 39.)

No. 9 or LARGE BENCH SETT.

THIS machine is the same as the head of No. 3, but is designed to be fastened to an ordinary wooden bench. It can be used with the same style of rivets and for the same purposes as No. 2, only having a longer arm it is much more convenient for riveting Brogans, Plow Shoes, and similar work where the long arm is needed.

(For extra parts see page 14.)



No. 9 or LARGE BENCH SETT.

(For dimensions see page 8.)

Under rental, per year - - - - - - $2.00

(For value of this machine see page 39.)

No. 3 or SETT ON STAND.

MANUFACTURERS who require a variety of lengths and styles of rivets will find the No. 3 the most serviceable machine, as it is light and strong, and with few changes, as explained below, can be fitted for any style of our rivets.

For these reasons it is especially adapted to the requirements of Harness Manufacturers, except for collar work, when the longer arm and additional room of the No. 8 machine are needed.

The same Jaws and Anvil Tip are used for both Shoe and No. 1 Belt Rivets, but a special Taper is required for each.

The SMALL and No. 3 Belt Rivets require special Jaws, Taper and Anvil-Tip for each.

(For extra parts see page 14.)

No. 3 or SETT ON STAND.

(For dimensions see page 8.)

Under rental, per year - - - - - - $3.00

(For value of this machine see page 39.)

No. 4 or SELF-FEEDING SETT.

THIS machine is designed for manufacturers using large quantities of rivets in work which requires but one or two lengths, such as Boots and Shoes, Brogans, light Belting and some classes of Harness work.

It is limited in its use to the *one style* of rivet for which it is fitted.

The following lengths of the various styles of rivets can be used: —

When fitted for the	SMALL			$\frac{2}{16}$	to	$\frac{4}{16}$	inclusive.
"	"	"	Shoe	$\frac{3}{16}$	to	$\frac{5}{16}$	"
"	"	"	No. 1 Belt,	$3\frac{1}{2}$	to	$\frac{7}{16}$	"
"	"	"	No. 3 Belt,	$\frac{4}{16}$	to	$\frac{8}{16}$	"

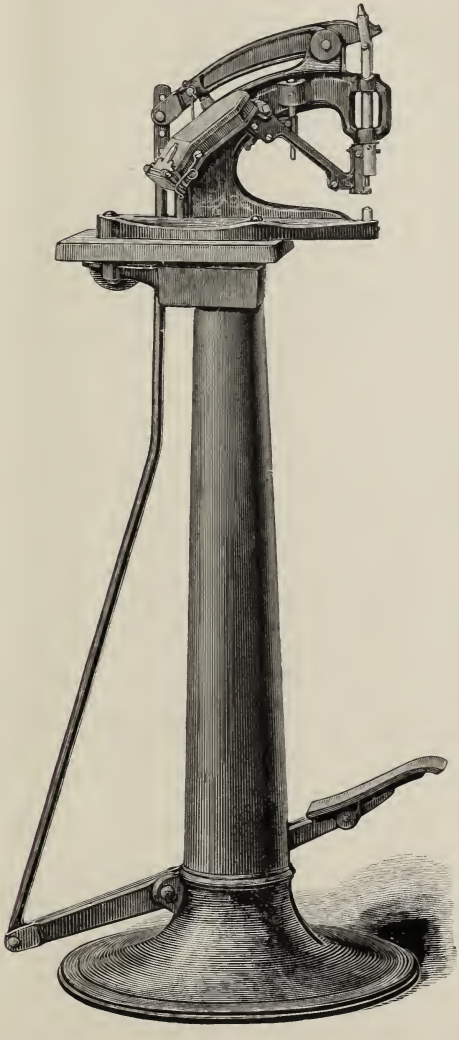
IF rivets longer than $\frac{8}{16}$ and different styles are required, one of the "Hand-feed" machines will be preferable.

If it is desired to use tinned rivets in this machine, electro-plated ones are recommended.

Rivets tinned in this way are smooth and offer no obstructions in feeding down the race-way.

In ordering, please state if electro-tinned rivets are to be sent.

When it is desired to rivet automatic buckles, we furnish special jaws by which this is easily and rapidly done.



No. 4 or SELF-FEEDING SETT.

(For dimensions see page 8.)

Under Rental, per Year - - - - - $5.00

(For value of this machine see page 39.)

No. 5 or SELF-FEEDING POWER SETT.

A MACHINE particularly adapted to the requirements of large Shoe manufacturers. As the Self-feeding Attachment is similar to that on No. 4 it can be used for rivets of the same styles and lengths, while possessing the advantage of being run by power.

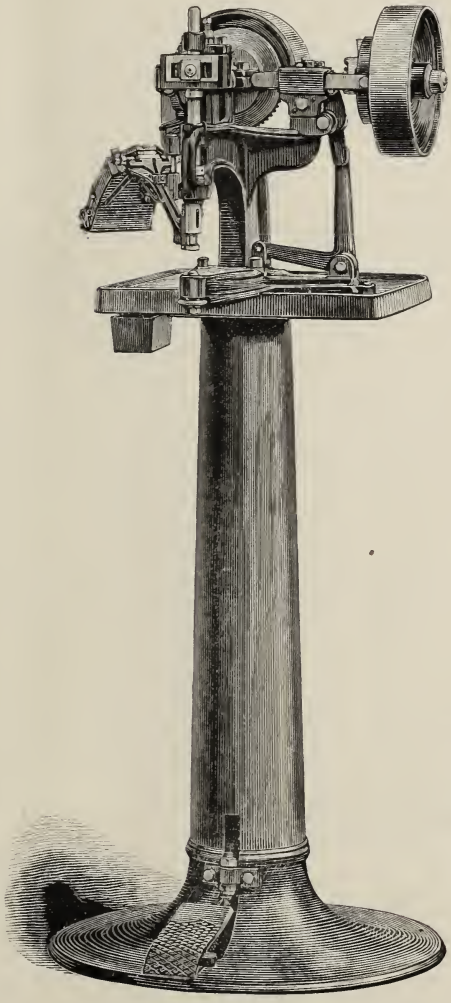
As the downward movement of the spindle is always the same, an adjustment adapting the machine to materials of different thicknesses is required.

An adjusting screw for this purpose will be found directly beneath the anvil, on the under side of the arm.

By its use the anvil can be raised or lowered, thus diminishing or increasing the distance between the taper and anvil to any desired extent.

When starting the machine, the anvil should be left quite low, gradually raising it until the right point is reached, to give the rivet the desired clinch.

Note. — A pulley for the shaft from which this machine is to be belted, will be furnished without charge if the exact size of the shaft and its speed accompanies the order.



No. 5 or SELF-FEEDING POWER SETT.

(For dimensions see page 8).

Under rental, per year - - - - - $10.00

(For value of this machine see page 39.)

No. 7 or SELF-FEEDING BELT SETT.

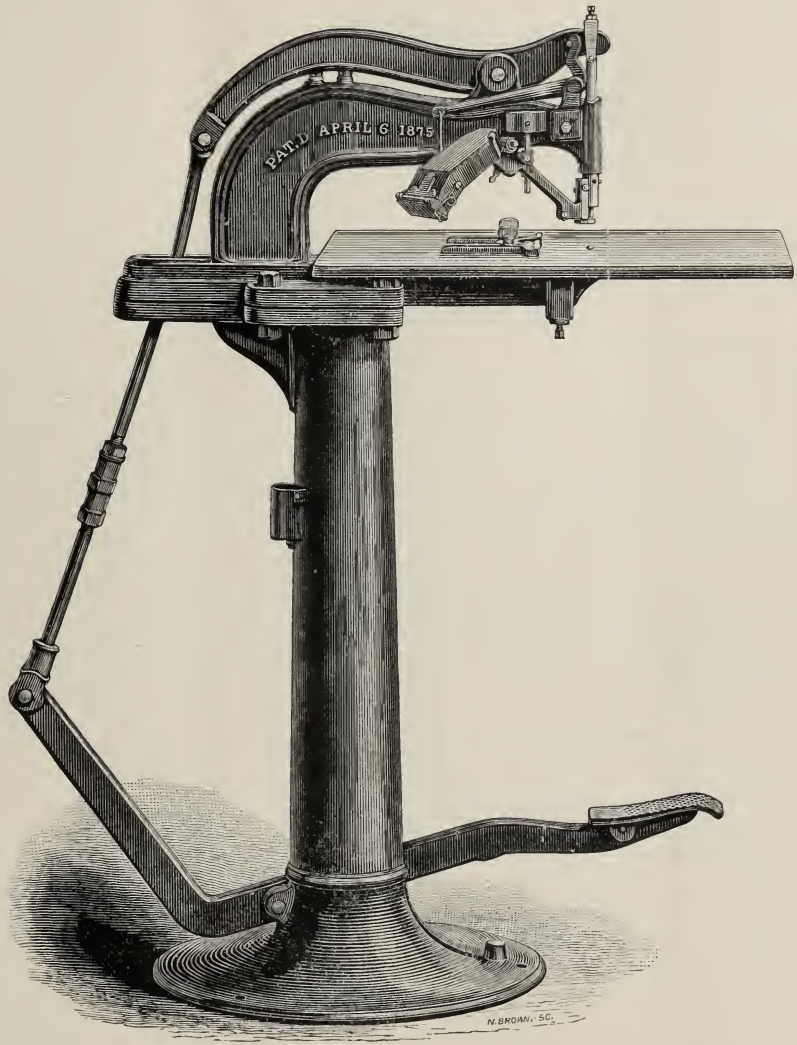
A MACHINE arranged especially for Belt Manufacturers. It has a wide table provided with gauges by means of which the rivets can be set at equal distances from the edge of the belting. If preferred, a "half-table" can be furnished of the same width as the larger one, but extending forward only to the anvil, as indicated by the dotted lines in the accompanying cut.

Size of large table 23½ inches wide, 29½ inches long.
" small " 23½ " " 15½ " "

WHEN fitted as a "Hand-feed" machine, any style or length of rivet can be used, as explained for Sett No. 3.

(For extra parts see page **14.**)

The self-feeding attachment is the same as those on Nos. 4 and 5, and can be used with rivets of the same styles and lengths. The No. 1 Belt rivets are, however, particularly adapted to this class of work.



No. 7 or SELF-FEEDING BELT SETT.

(For dimensions see page 8.)

Hand-feed, under rental, per year - - - $6.00
Self-feeding, " " " " - - - 7.00

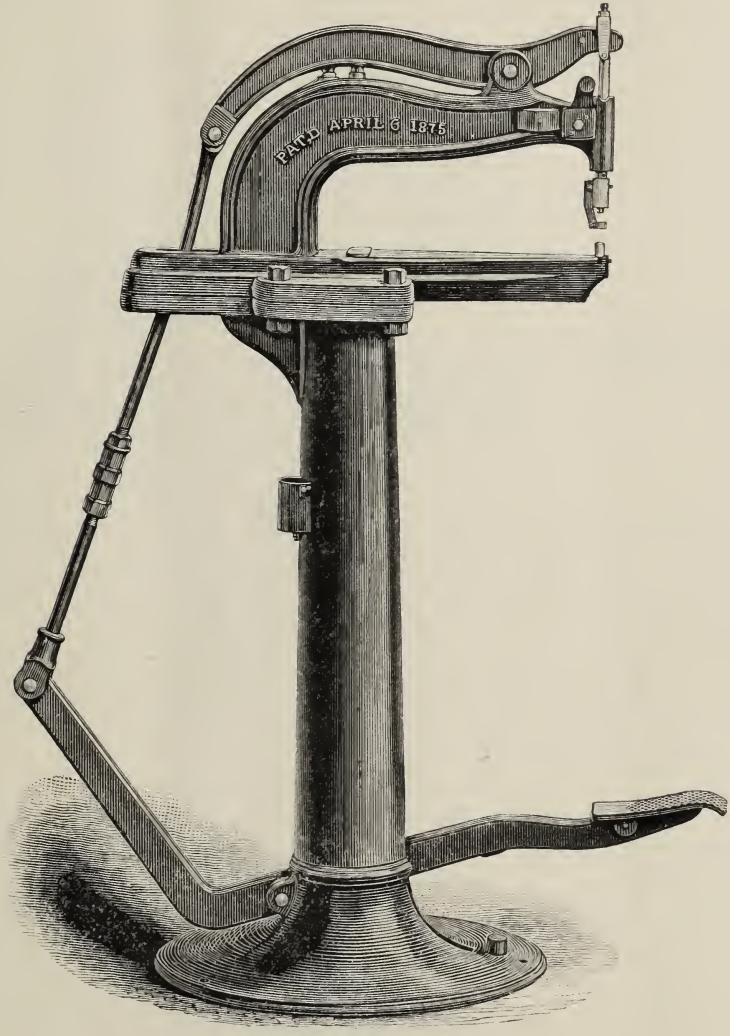
(For value of this machine see page 39.)

No. 8 or BAG SETT.

A HEAVY, long-armed machine in which rivets of any length or style can be used by changing the parts, as explained for Sett No. 3.

It is adapted to the heaviest Harness work (especially Horse Collars), Sample Cases, Bags, Sole-leather Trunks, etc.

This machine can also be fitted with the Self-feeding attachment and be used with the same rivets as explained for the Sett No. 4.



No. 8 or BAC SETT.

(For dimensions see page 8.)

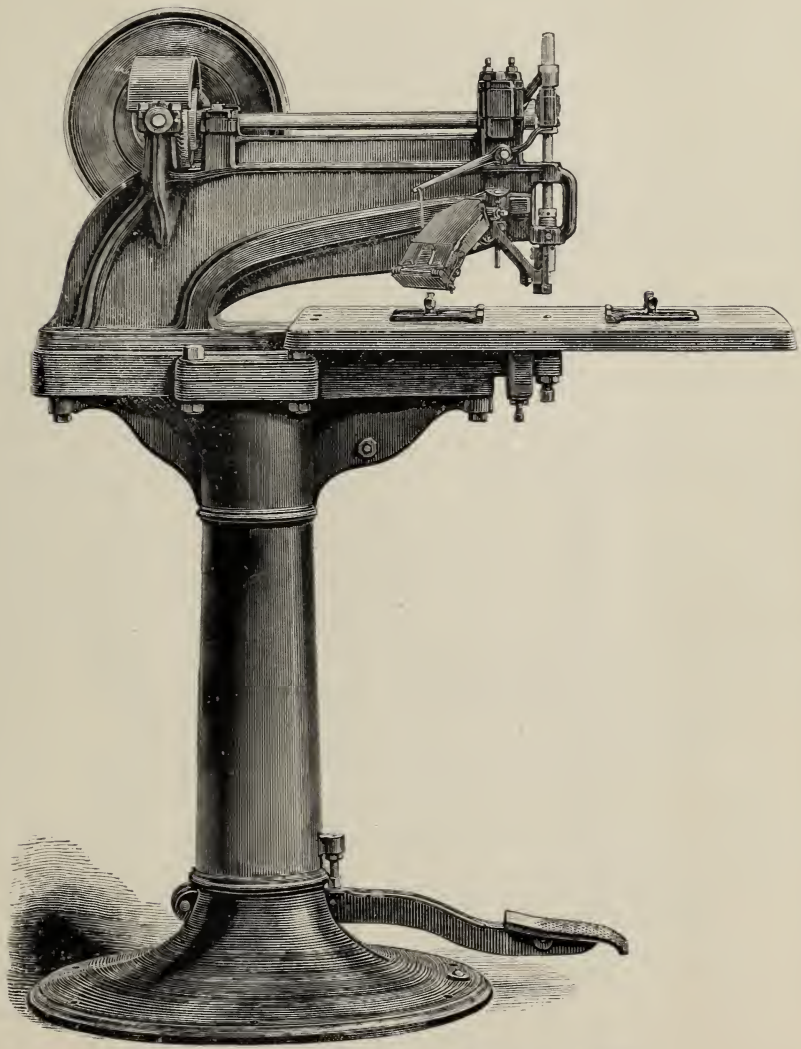
Hand-feed, under rental, per year - - - $6.00
Self-feeding, " " " " - - - 7.00

(For value of this machine see page 39.)

No. 10 or POWER BELT SETT.

THIS machine, like the No. 7, is designed especially for Belt manufacturers, and can be used for the same styles of rivets as explained for that Sett.

For directions for operating and note in regard to pulley, see page 22.



No. 10 or POWER BELT SETT.

(For dimensions see page 8.)

Under rental, per year - - - - - - $10.00

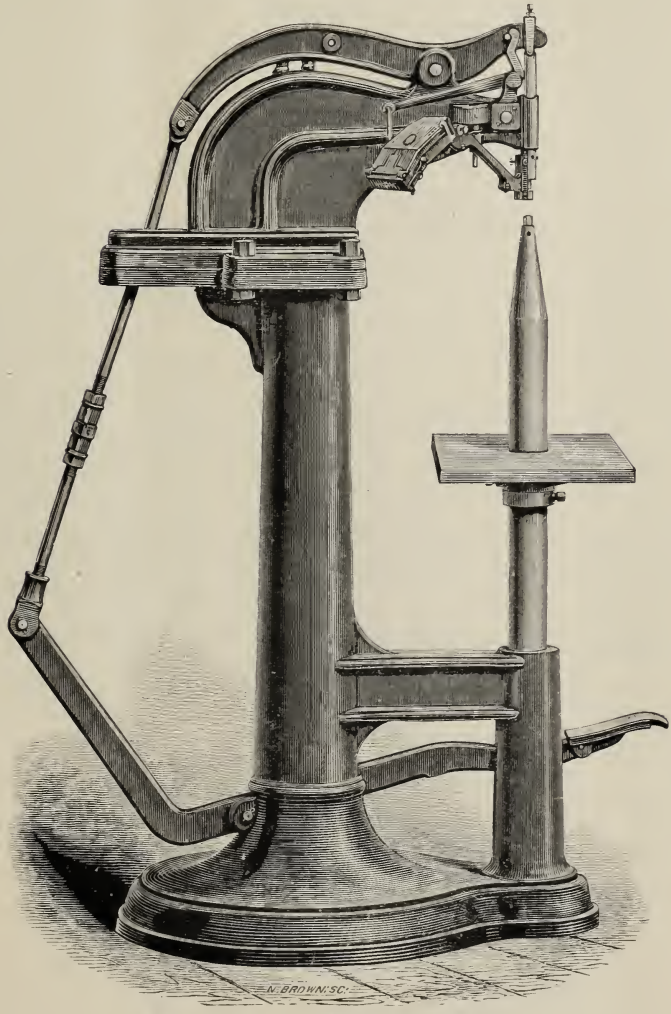
(For value of this machine see page 39.)

No. 11 or TRUNK SETT.

IN the manufacture of sole-leather trunks and extension-cases, two machines are required: one for riveting the sides and ends (either No. 7 or 8) and one for the bottoms.

This machine is designed for the latter purpose. The post, which is provided with an adjustable table on which to rest the trunk while it is being riveted, is 24 inches in height, and stands 10½ inches from the main column.

As a SELF-FEEDING machine, it can be used with the same styles of rivets as described for Sett No. 4; and as a HAND-FEED, with any style or length as described for Setts Nos. 3 and 8.



No. 11 or TRUNK SETT.

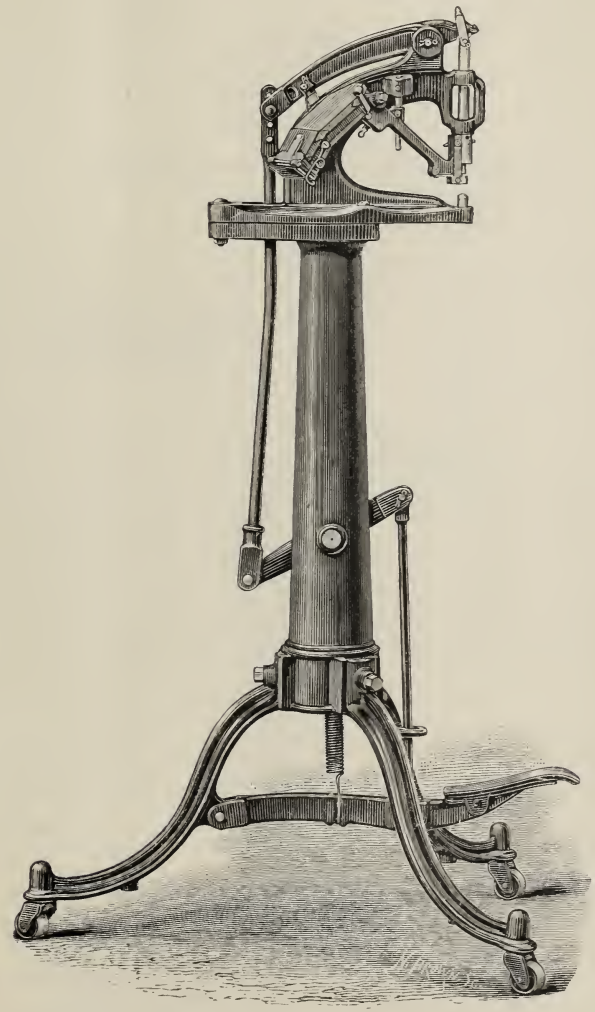
(For dimensions see page 8.)

Hand-feed, under rental, per year - - - $7.00
Self-feeding, " " " " - - - 8.00

(For value of this machine see page 39.)

No. 12 or RUBBER SETT.

TO meet the special requirements of Rubber Shoe Manufacturers, Sett No. 12 has been arranged with legs and castors. With this exception it is similar to Sett No. 4, and can be used with the same styles of rivets.



No. 12 or RUBBER SETT.

(For dimensions see page 8.)

Under rental, per year - - - - - - $5.00

(For value of this machine see page 39.)

SMALL POWER POST SETT.

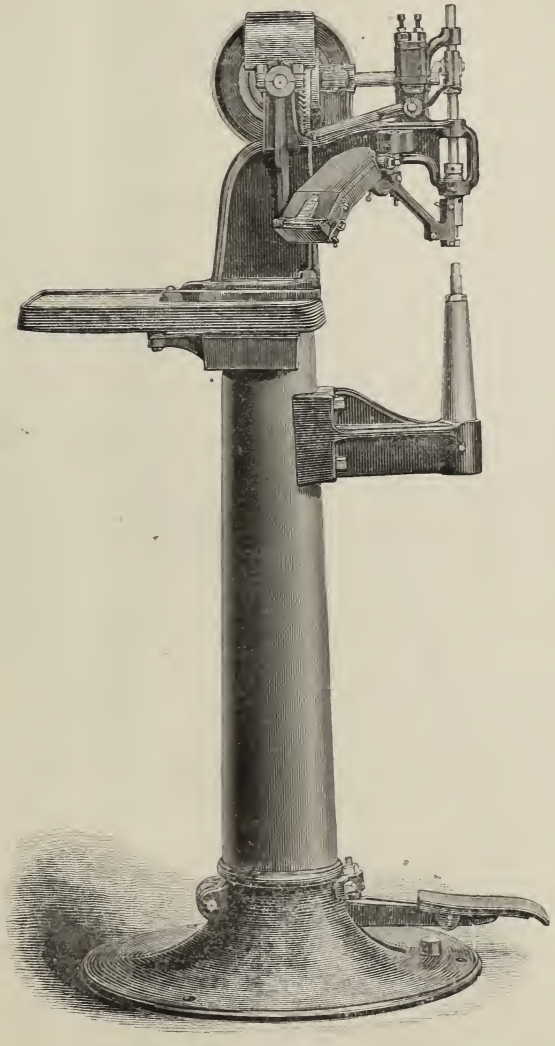
THIS machine is the same as the No. 5, except that it is provided with a bracket and post instead of the regular arm.

DIMENSIONS.

Height of Post with anvil set for $\frac{3}{16}$ Rivet,	$11\frac{7}{8}$ inches.
" " " " " " " $\frac{5}{16}$ "	$11\frac{3}{4}$ "
Depth of Bracket below post,	3 "
Distance from centre of post to casting,	$7\frac{1}{2}$ "

The length of post and position of the bracket will be changed to meet any special requirements and without extra charge if the amount of rivets used is sufficient to warrant the change.

This Machine is not kept in stock.



SMALL POWER POST SETT.

Under rental, per year - - - - - - $10.00

(For value of this machine see page 39.)

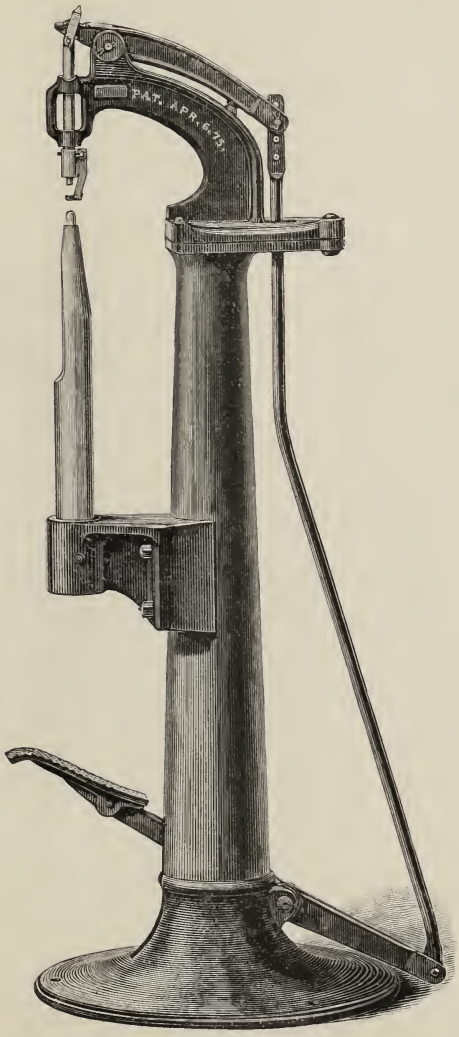
SMALL POST SETT.

THIS is another special Post Sett similar in all respects (with the exception of the post and bracket) to the No. 3. The changes referred to in the explanation of the "Power Post Sett" can also be made on this machine, under the same conditions.

DIMENSIONS.

Height of post including Anvil - -	19½ inches.
Depth of bracket below post - - -	3¼ "
Distance from centre of post to casting -	5 "

This Machine is not kept in stock.



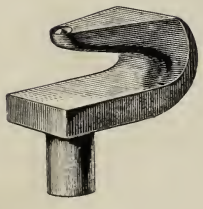
SMALL POST SETT.

Hand-feed, under rental, per year - - - $3.00
Self-feeding, " " " " - - - 5.00

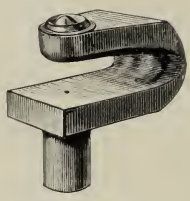
(For value of this machine see page 39.)

LOOP ANVILS,

For Riveting Loops on Straps.



No. 1.



No. 2.

No. 1. For light straps under one inch in width. This can be used only with the No. 1 Rivets.

No. 2. For medium and heavy straps over one inch in width. This is the best Loop Anvil for all loops for which it can be used, as the tip can be changed, thus adapting it for either the No. 1 or No. 3 rivets.

(For price of Loop Anvils see page 14.)

BUSHING.

In some kinds of work it is desirable to clinch the rivet on a small leather washer. This bushing is used for holding the washer directly over the anvil.

ALL rented machines are forwarded on the understanding that the parties renting same are responsible for them, and in case of loss are to pay for them as follows: —

For No. 2, or Bench	$12 00
No. 9, or Large Bench	12 00
No. 3, or Hand Feed	20 00
No. 4, or Self Feed	35 00
No. 5, or Power	75 00
No. 7, or Hand Feed Belt	40 00
No. 7, or Self Feed Belt	50 00
No. 8, or Hand Feed Bag	40 00
No. 8, or Self Feed Bag	50 00
No. 10, or Power Belt	75 00
No. 11, or Hand Feed Trunk	50 00
No. 11, or Self Feed Trunk	60 00
No. 12, or Self Feed Rubber	35 00
Small Power Post	75 00
Small Hand Feed Post	20 00
Small Self Feed Post	35 00